



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571

Job Sheet 174051-A



Part No: D2571

Job Qty: 1 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Job Created: 5/31/18

Due Date: 3/30/18

Type: SOLD

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier			Sign-off
					Setup	Run	Workcenter	Supplier	Lead Time	
					hrs	Hrs				
90	Start up Operation	1 Ea		3/30/18	0.00	0.00	Start Up Machining			
100	CNC Vertical Machining	1 pcs		3/30/18	0.57	1.61	HAAS 1			
110	Mill Conv	1 pcs		3/30/18	0.00	0.15	Mill Conv 1			
120	QC	1 pcs		3/30/18	0.00	0.00	QC2			
130	QC	1 pcs		3/30/18	0.00	0.00	QC8			
140	HandFinish	1 pcs		3/30/18	0.00	0.03	HandFinish1			
150	Powdercoat	1 pcs		3/30/18	0.00	0.04	Powdercoat1			
160	QC	1 pcs		3/30/18	0.00	0.00	QC3			
170	Packaging	1 pcs		3/30/18	0.00	0.00	Packaging3			
180	QC21-SA	1 Ea		3/30/18	0.00	0.00	QC21			

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
110 - Machine keyway as per dwg D2571 & D2572
120 - Inspect on CMM as per folio CMMA022.
150 - START TIME: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	1 Ea (1 ea)	90-Start up Operation	

5069074 → 5076970

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	1	45	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010	3.505		

			- 0.000	3.495
4	Saddle, Fwd Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Fwd Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000

36

Saddle, Fwd Outboard

0.023Inches + 0.020
- 0.000

0.043
0.023

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571

Job Sheet 174051



Part No: D2571

Job Qty: 15 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea	3/28/18	3/28/18	0.00	0.00	Start Up Machining		SBL 18/5/22
100	CNC Vertical Machining	15 pcs	3/29/18	3/29/18	0.57	24.19	HAAS 1		
110	Mill Conv	15 pcs	3/29/18	3/29/18	0.00	2.31	Mill Conv 1		
120	QC	15 pcs	3/29/18	3/29/18	0.00	0.00	QC2		
130	QC	15 pcs	3/29/18	3/29/18	0.00	0.00	QC8		
140	HandFinish	15 pcs	3/29/18	3/29/18	0.00	0.50	HandFinish1		
150	Powdercoat	15 pcs	3/30/18	3/30/18	0.00	0.60	Powdercoat1		
160	QC	15 pcs	3/30/18	3/30/18	0.00	0.00	QC3		
170	Packaging	15 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3		
180	QC21-SA	15 Ea	3/30/18	3/30/18	0.00	0.00	QC21		

Part Op 100 - Program Batch No. 5072785 Double check by: 7 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
 110 - Machine keyway as per dwg D2571 & D2572
 120 - Inspect on CMM as per folio CMM022.
 150 - START TIME: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	15 Ea (1 ea)	90-Start up Operation	

5069074 → 5072784

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	15	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010	3.505		

Plex 3/9/18 12:49 PM Dart.Gagnon.Michelle

			- 0.000	3.495
4	Saddle, Fwd Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Fwd Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000

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36 Saddle, Fwd Outboard

0.023Inches + 0.020
- 0.0000.043
0.023

Plex 3/9/18 12:49 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 174051
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.008	8.008	8.008		
F	0.490	0.510		0.501	0.501	0.502	0.497		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.569	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.134	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.253	0.254	0.253	0.253		
S	0.115	0.135		0.120	0.128	0.125	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.962	2.960		
V	0.230	0.250		0.245	0.245	0.247	0.245		
W	0.115	0.135		0.123	0.123	0.125	0.123		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.255	0.255	0.255		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.250	0.255	0.255	0.255		
AH	0.240	0.260		0.252	0.250	0.252	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: SBC	DAS
Date: 18/5/27	57
	9-89

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 174051
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	62	73	84		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.008	8.012	8.010	8.000		
F	0.490	0.510		0.502	0.510	0.505	0.501		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.505	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.577	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.130	0.128	0.135	0.131		
Q	0.115	0.135		0.125	0.125	0.126	0.126		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.130	0.125	0.136	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		0.245	0.245	0.244	0.241		
W	0.115	0.135		0.123	0.121	0.122	0.125		
X	0.308	0.313		0.312	0.312	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.631	0.630	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.253	0.253		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.128	0.135	0.120		
AG	0.240	0.280		0.260	0.260	0.255	0.260		
AH	0.240	0.260		0.250	0.250	0.257	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 9	2 10	3 11	4 12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.133	.131	.133	.128		
Q	0.115	0.135		.126	.127	.125	.126		
R	0.240	0.260		.253	.255	.253	.253		
S	0.115	0.135		.130	.129	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.963	2.963	2.963		
V	0.230	0.250		.242	.242	.241	.242		
W	0.115	0.135		.121	.122	.124	.122		
X	0.308	0.313		.312	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.253	.254	.254		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.123	.133	.127	.128		
AG	0.240	0.280		.255	.255	.255	.260		
AH	0.240	0.260		.251	.252	.250	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 174051
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14 ²	15 ²	4		
A	0.438	0.443							
B	1.745	1.755							
C	3.495	3.505							
D	1.745	1.755							
E	7.990	8.010							
F	0.490	0.510							
G	0.257	0.262		0.257					
H	0.375	0.380		0.375					
I	0.490	0.510		0.490					
J	1.174	1.184		1.174					
K	0.558	0.578		0.568					
L	1.174	1.184		1.174					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.874					
P	0.115	0.135		0.133					
Q	0.115	0.135		0.126					
R	0.240	0.260		0.254					
S	0.115	0.135		0.130					
T	0.178	0.198		0.188					
U	2.940	2.980		2.962					
V	0.230	0.250		0.243					
W	0.115	0.135		0.123					
X	0.308	0.313							
Y	0.760	0.765							
Z	0.352	0.372							
AA	0.470	0.530		0.500					
AB	0.615	0.635							
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.254					
AE	1.375	1.395		1.385					
AF	0.115	0.135		0.128					
AG	0.240	0.280		0.250					
AH	0.240	0.260		0.249					
AI	2.000	2.020		2.000					
AJ	0.023	0.043							
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	